

## Work Order ID 54341

December 8, 2009 8:48:33 AM



Page 1

Item ID: D3772-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Leg

Start Date: 08/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: *RF*Date: *09-12-08*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3772	Rev A

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank 31.500" long

0.00

0.00

*RF 09-11-08**9 0**Pto ->*

110



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Folio FA787 Rev: *AA* & Dwg D3772 Rev: *A*

0.00

0.00

*RF 09/12/08**-9 8 0*

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

*RF 09/12/08**9 8 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3772-1 PAR #: \_\_\_\_\_ Fault Category: Machined Parts NCR: Yes No DQA: / Date: 05-12-30  
 Resolution: re-work Disposition: re-work QA: N/C Closed: / Date: 05-12-31

NCR: 54341		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/12/08	110	One part have center Drill hole off center.  R.K. Bad origin By operator <del>part moved.</del> R.C. LOA	<u>/</u>	<u>No replace. Touch-up affected area will weld per QSI cut grind flush.</u>	<u>BF</u> 09/12/08	<u>/</u> 05-12-10	<u>/</u> 05-12-09	<u>/</u> 05-12-09

NOTE: Date & initial all entries

**Work Order ID 54341**

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Item ID: D3772-1

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Setup Start



Revision ID:

Stop



Item Name: Back Leg

Start Date: 08/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DIP 09/12/14

9

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3772-2- deburr-3-bend tube as per dwg D3772

7 M.L 09/12/15

(9X)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2 8 09/12/15

(X9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54341**

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Page 3

Item ID: D3772-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Leg

Start Date: 08/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location JSY

0.00



Packaging

Memo

0.00

Packaging

9/12/15 QSP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/17 MF  
09-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 8, 2009 8:48:38 AM

Page 1

Work Order ID: 54341

Parent Item: D3772-1

Parent Item Name: Back Leg

Comments:

Start Date: 08/12/2009

Required Date: 16/12/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Loc Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR1.250W.125		Purchased	No			110	f	20.0000	55.2674			

304 RD Tube 1.250 x .125w

316 9/12/09-12-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

20

110316

20

18019

x 3 parts

→ + 3' scrap.

15.5'

7.75

SB 09/12/12  
SB 09/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	541341
<b>Description: Back Leg</b>		<b>Part Number:</b>	D3772-1
<b>Inspection Dwg: D3772 Rev: A</b>		<b>Page 1 of 1</b>	

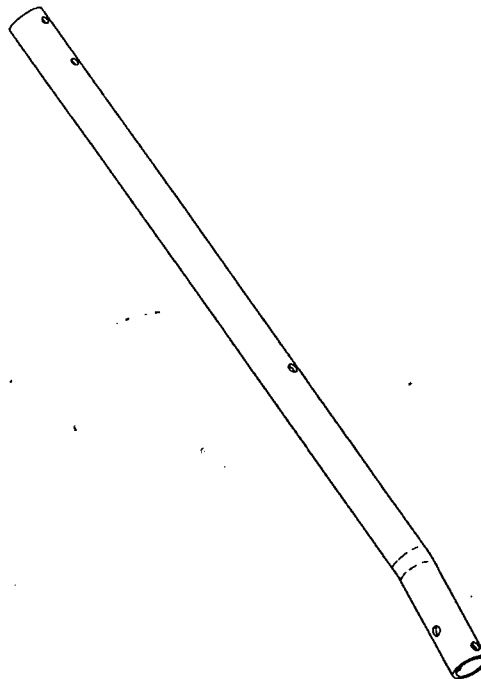
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	+/-0.030	.498	✓			
1.70	+/-0.030	1.702	✓			
Ø0.257	+0.006/-0.001	.260	✓			
12.56	+/-0.030	12.560	✓			
Ø0.323	+0.006/-0.001	.325	✓			
0.61	+/-0.030					
Ø0.323	+0.006/-0.001	.325	✓			
Ø1.250	+/-0.010	1.250	✓			
0.125	+/-0.010	.115	✓			
3.75	+/-0.030					
1.10	+/-0.030	1.100	✓			
0.38	+/-0.030					
Ø0.323	+0.006/-0.001	.325	✓			

<b>Measured by:</b>	BF	<b>Audited by:</b>	DJP	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09/12/08	<b>Date:</b>	09/12/14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.10.17	New Issue	KJ/DD	
B	09.05.19	Dimensions 22.00 & 10° removed	KJ	



**D3772-1 BACK LEG**

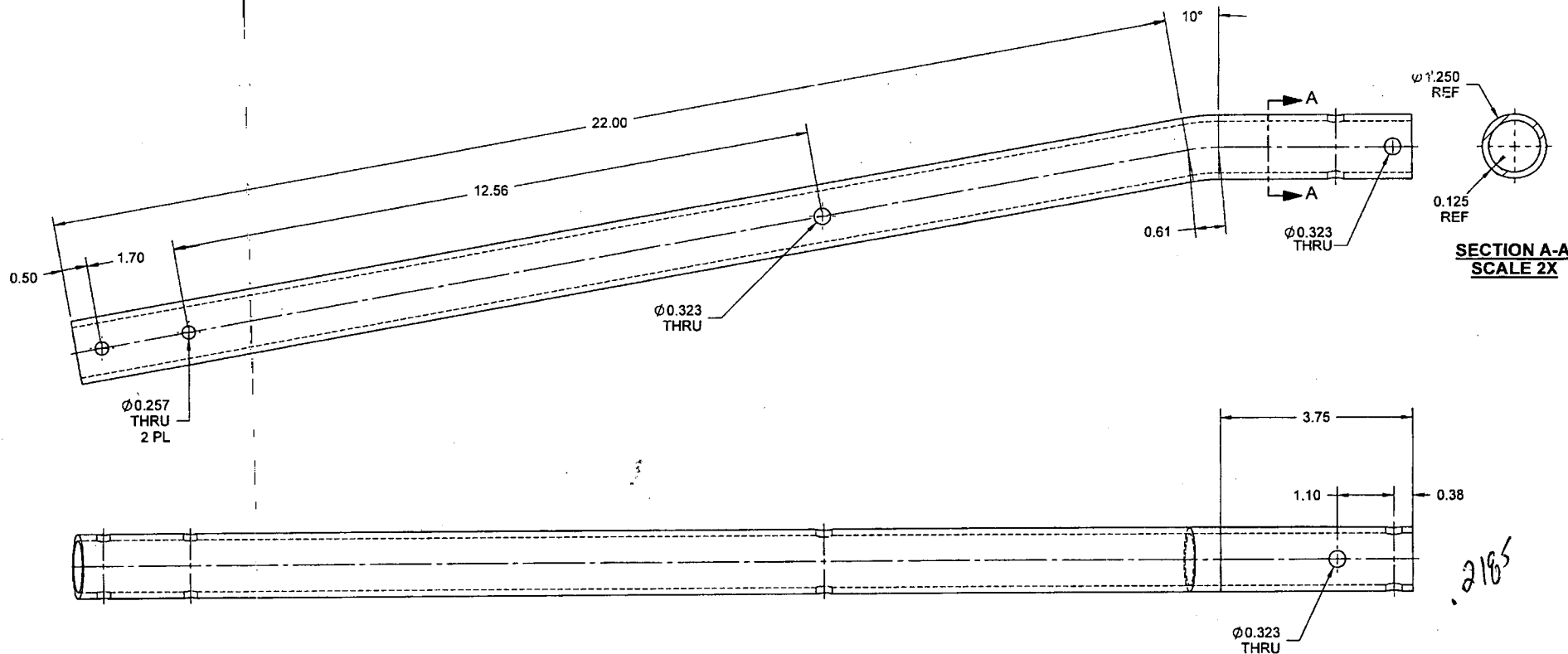
SHOWN  
REF  
ENG  
UNCONTROL  
SUBJECT TO  
WITH  
WORK  
NO. 54341  
*MR 08-12-8*

**RELEASED**  
*08-06-13*

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.26 lbs

A		NEW ISSUE		HS	08.06.03
REV.		DESCRIPTION		BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	HS				
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3772</b>		SHEET 1 OF 2	
MFG. APPR.	<i>[Signature]</i>	TITLE <b>BACK LEG</b>		SCALE <b>NTS</b>	
DE APPR.	<i>[Signature]</i>	DATE <b>08.06.03</b>		<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D3772-1 BACK LEG**

**RELEASED**  
08.06.16/17

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AA	DRAWING NO.	REV. A
MFG. APPR.	AA	D3772	SHEET 2 OF 2
APPROVED	AA	TITLE	SCALE
DE APPR.	AA	BACK LEG	NTS
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W16 54341